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SPLIT

DART AEROSPACE LTD		Work Order:	19666 6
Description: Fwd Crosstube		Part Number:	D2889
Drawing: D2889 Rev. B; D6005 Rev. A		Qty:	1 79
		Page 1 of 2	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller <i>Dwg. not required RF 02.11.05</i>	<i>HA</i>	03.09.19	19
2	PG	Issue P/O: <i>7053028</i> a) Extrude as per Dwg D6005 length = 180" (Ref. D6005-180) b) Material: 7075-T6/T6511 (WW-T-700/7 or QQ-A-225/9 or QQ-A-200/11)) Seamless aluminum tube c) Minimum ultimate tensile strength = 77ksi d) Minimum tensile yield strength = 66ksi e) Material certification required		03.09.22	19
3	RG	Receive and inspect for transit damage Ensure material certification attached	<i>Q</i>	04.01.05	22
4	QC6	Inspect dimensions as per Dwg D6005 and check 180" length	<i>AB</i>	04.02.11	22 PTO
5	FP	Acid etch and alodine as per QSI 005 4.1 Inside and outside of tube	<i>2</i>	07.02.11	22
6	LG	Bend as per Dwg D2889 and Folio FT001 Sign Page 2	<i>See shell 2 HA</i>		
7	QC6	Inspect dimensions per Dwg D2889 Sign Page 2			
8	LG	Deburr and Polish Sign Page 2			
9	FP	Acid etch and alodine as per QSI 005 4.1 Inside and outside of tube Sign Page 2	<i>MM</i>	05.03.07	1
10	QC5	Inspect work to Step 9 Sign Page 2	<i>Z</i>	05.03.07	1
11	ST	Identify and stock	<i>CY</i>	05/03/07	1
12	AC	Cost / part: <i>158925</i>	<i>S</i>	05.05.10	1
13	DC	Close W/O <i>739.00</i> Inspect Level 21	<i>HA</i>	05.05.10	1

Rev	Date	Change	Revised By	Approved
A	99.05.31	New Issue, ECN 200	DM	
B	00.04.11	Remove Painting step	EC	
C	02.10.18	Re-format; Added spec	KJ <i>RF</i>	<i>JA</i>

RELEASED
02/10/30 RF

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE					
DATE	STEP	Description of NC section A	Corrective Action Section B	Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
04.02.11	41	Dimensions should be actual dimensions Ø 2.750 OD Ø 2.000 ID 0.375 Wall Variance between 0.375" and 0.361"	acceptable OD only 0.003" out of tolerance used on Extended gear find xtrks. - QC. (per D6005, OD is ± 0.006 wall is ± 0.015)	B 04.02.11	B 04.02.11	# 04.02.11	B 04.02.11
	6	TUBE IS OVERSIZED	SCRAP	# 04.05.11	N/A	# 04.05.11	

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

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W/O Step	A	B	C	D	E	F	G	H	I	J	K	L
6	DP 04/05/11	DP 04/05/11	DP 04/05/11	DP 04/05/11	DP 04/05/11	DP 05/23/02	DP 05/23/02					
7	DP 04/05/11	DP 04/05/11	DP 04/05/11	DP 04/05/11	DP 04/05/11	DP 05/23/02	DP 05/23/02					
8							DP 05/23/02					
9												
10												

Save ED for D705-596-101
 SPAN is 119.125" angles 57°, 57°
 04/05/11

RELEASED
 02/10/30 RE